

Date: Wednesday, 6/6/2007 3:05:57 PM
 User: Kim Johnston

Process Sheet

(Handwritten signature)

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : ADAPTER
 Job Number : 32830
 Estimate Number : 12674
 P.O. Number : *N/A*
 This Issue : 6/6/2007 S.O. No. : *NA*
 Prsht Rev. : NC
 First Issue : *MA* Type : MACHINED PARTS
 Previous Run : 31862
 Part Number : D35733
 Drawing Number : D3573 REV.A
 Project Number : N/A
 Drawing Revision : *A*
 Material : *N/A*
 Due Date : 6/27/2007 Qty: *3* Um: Each
 Written By : *(Signature)*
 Checked & Approved By : *07-06-07*
 Comment : Est Rev:A New Issue 07-01-29 JLM

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M6061T6B0500X02500 6061-T6 Bar .50" x 2.5"



Comment: Qty.: 0.3066 f(s)/Unit Total : 6.1320 f(s)

.93 f.

6061-T6 Bar .50" x 2.5"

Batch: *M104366*

(Signature)

070808

2.0 BAND SAW BAND SAW



Comment: BAND SAW

Cut blank 3.500" long

(Signature)

070808

3

3.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

Machine as per Folio FA673 and Dwg D3573

N/A Machined Manually

070808

3

4.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

070808

3

5.0 QC8 SECOND CHECK



Comment: SECOND CHECK

BG 07-08-09

3

6.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

BR

07-08-09

(Signature)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: 12 Date: 06/10
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 6/6/2007 3:05:58 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ADAPTER

Job Number: 32830

Part Number: D35733

Job Number:



Seq. #:

Machine Or Operation:

Description :

7.0

POWDER COATING

POWDER COATING



M104846



(3x)

Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

M.K 07/08/09

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

PC 7/8/10 (3)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

PC 7/8/10 (3)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



(3)

Comment: FINAL INSPECTION/W/O RELEASE

PC 7/8/10

Job Completion



C 207/08/10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

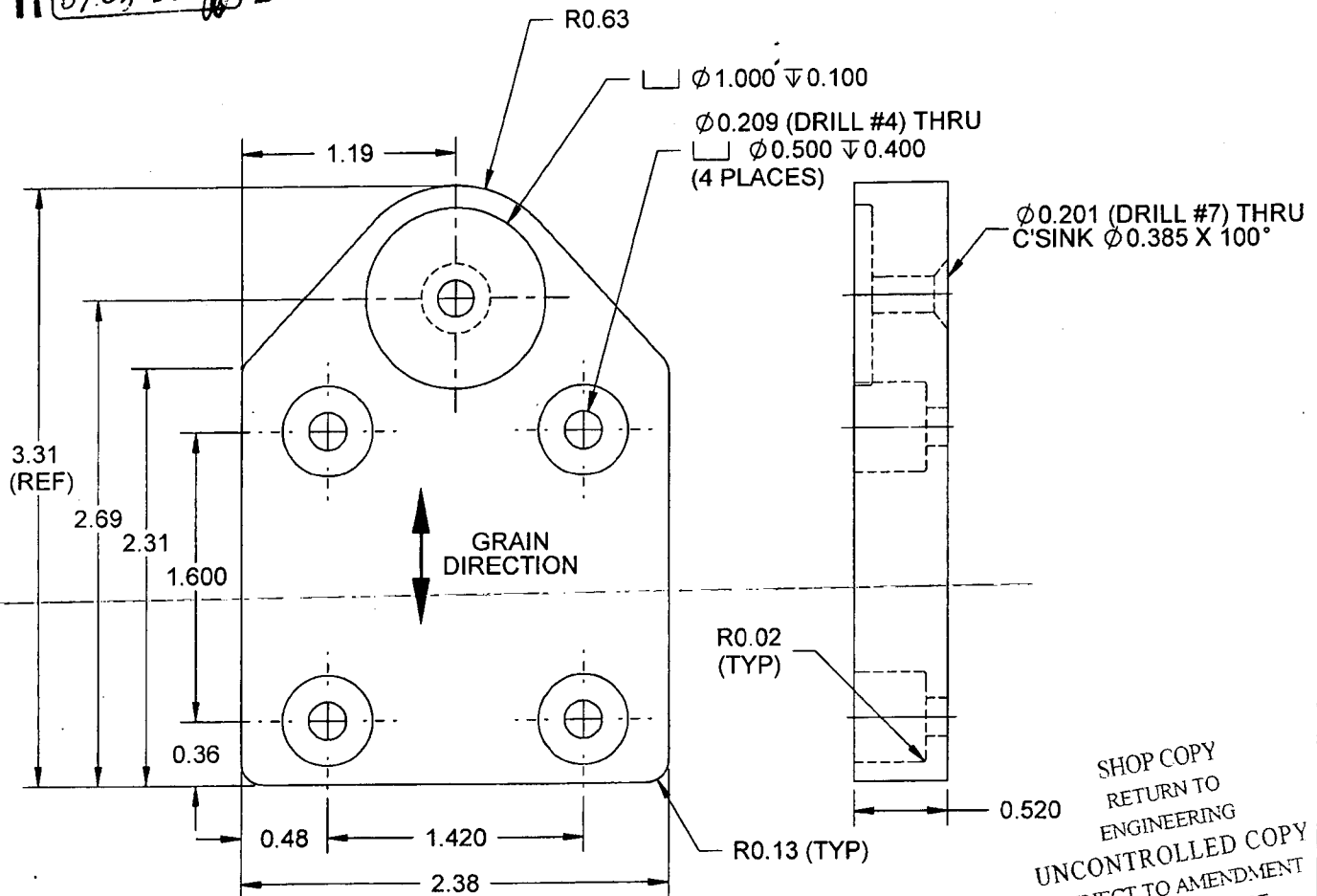
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

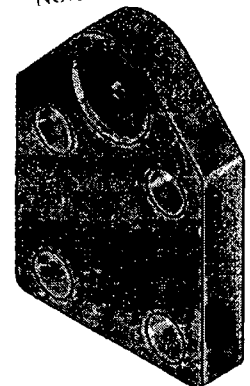
DESIGN <i>LE</i>	DRAWN BY <i>LE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3573	REV. A SHEET 1 OF 4
DATE 07.02.19	TITLE ADAPTER		SCALE 1:1
REV A	DATE 07.02.19	DESCRIPTION NEW ISSUE	

RELEASED
07.03.22**D3573-1 ADAPTER**

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WITHOUT NOTICE
WORK ORDER
NO. **32830**

NOTES:

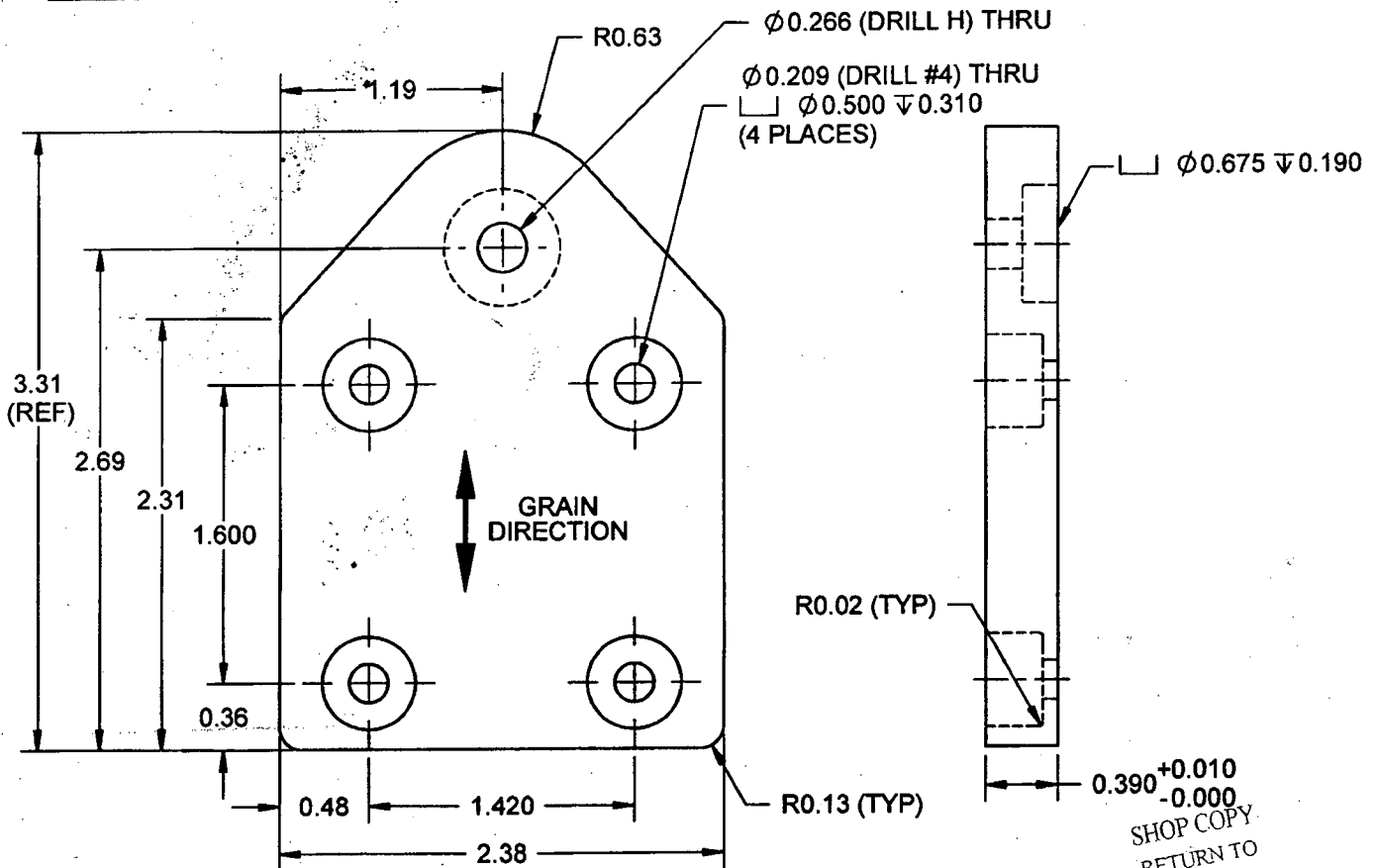
- 1) MATERIAL: 6061-T6 (OR T651/T6510/T6511/T62) ALUMINUM BAR
PER QQ-A-225/8 OR QQ-A-200/8 OR AMS 4117/4128/4115/4116 OR AMS 4160
(REF DART SPEC M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "GREY SANDTEX" (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3573-1" USING FINE POINT PERMANENT INK MARKER
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX

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CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3573	REV. A SHEET 2 OF 4
DATE 07.02.19	TITLE ADAPTER		SCALE 1:1

RELEASED
07.04.02**D3573-3 ADAPTER****NOTES:**

- 1) MATERIAL: 6061-T6 (OR T651/T6510/T6511/T62) ALUMINUM BAR
PER QQ-A-225/8 OR QQ-A-200/8 OR AMS 4117/4128/4115/4116 OR AMS 4160
(REF DART SPEC M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "GREY SANDTEX" (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3573-3" USING FINE POINT PERMANENT INK MARKER
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX

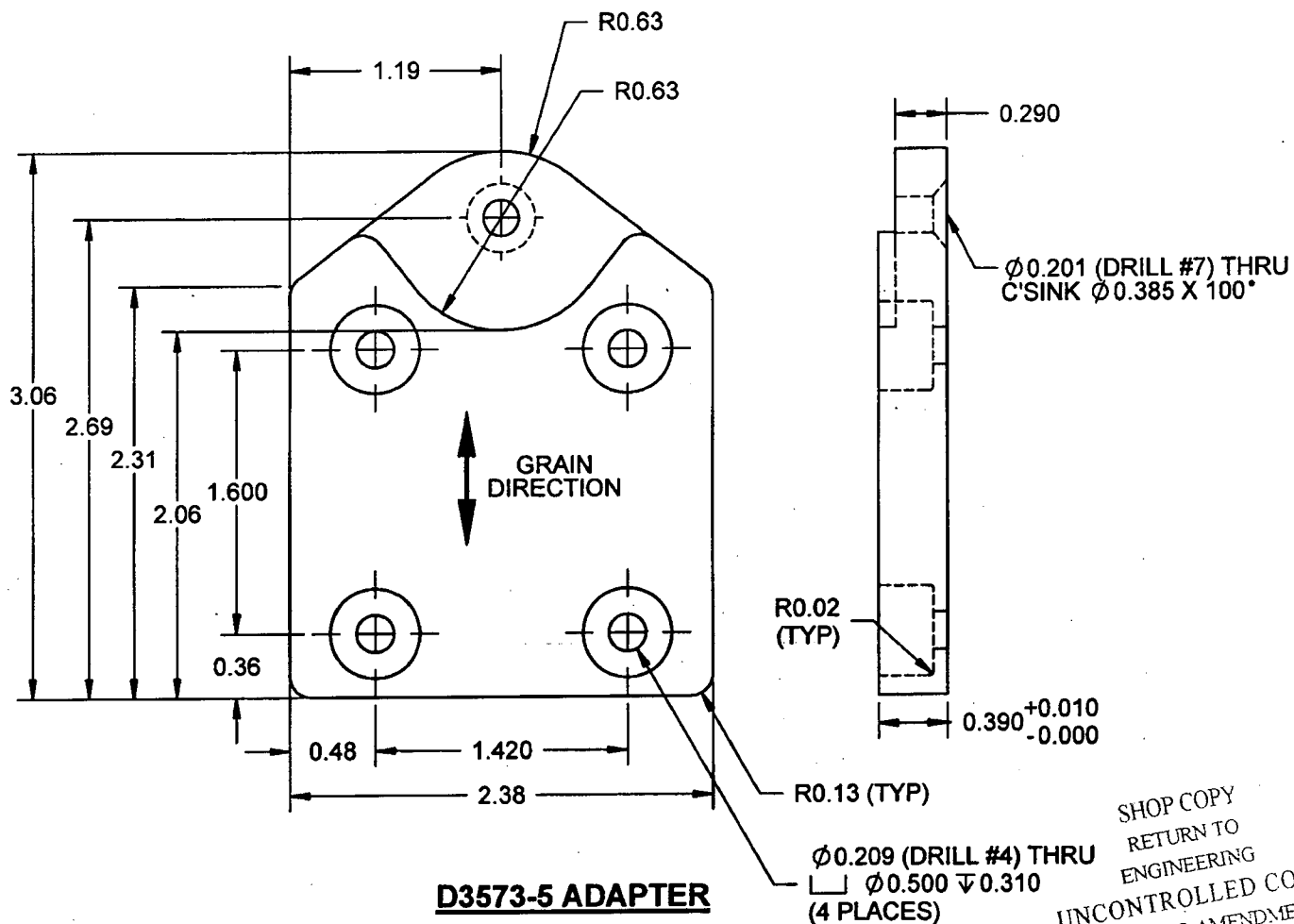
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NO. **32830**

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CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3573	REV. A SHEET 3 OF 4
DATE 07.02.19		TITLE ADAPTER	SCALE 1:1

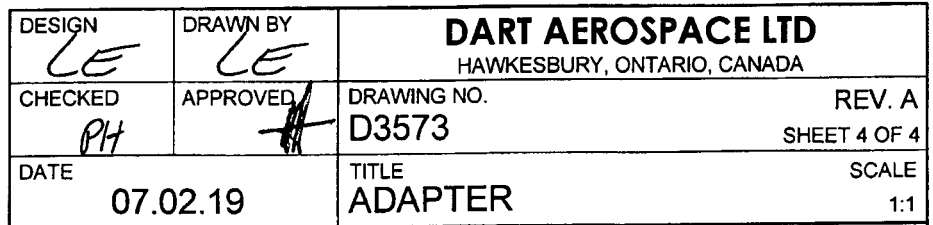
RELEASED
07.04.02**NOTES:**

- 1) MATERIAL: 6061-T6 (OR T651/T6510/T6511/T62) ALUMINUM BAR
PER QQ-A-225/8 OR QQ-A-200/8 OR AMS 4117/4128/4115/4116 OR AMS 4160
(REF DART SPEC M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "GREY SANDTEX" (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3573-5" USING FINE POINT PERMANENT INK MARKER
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX

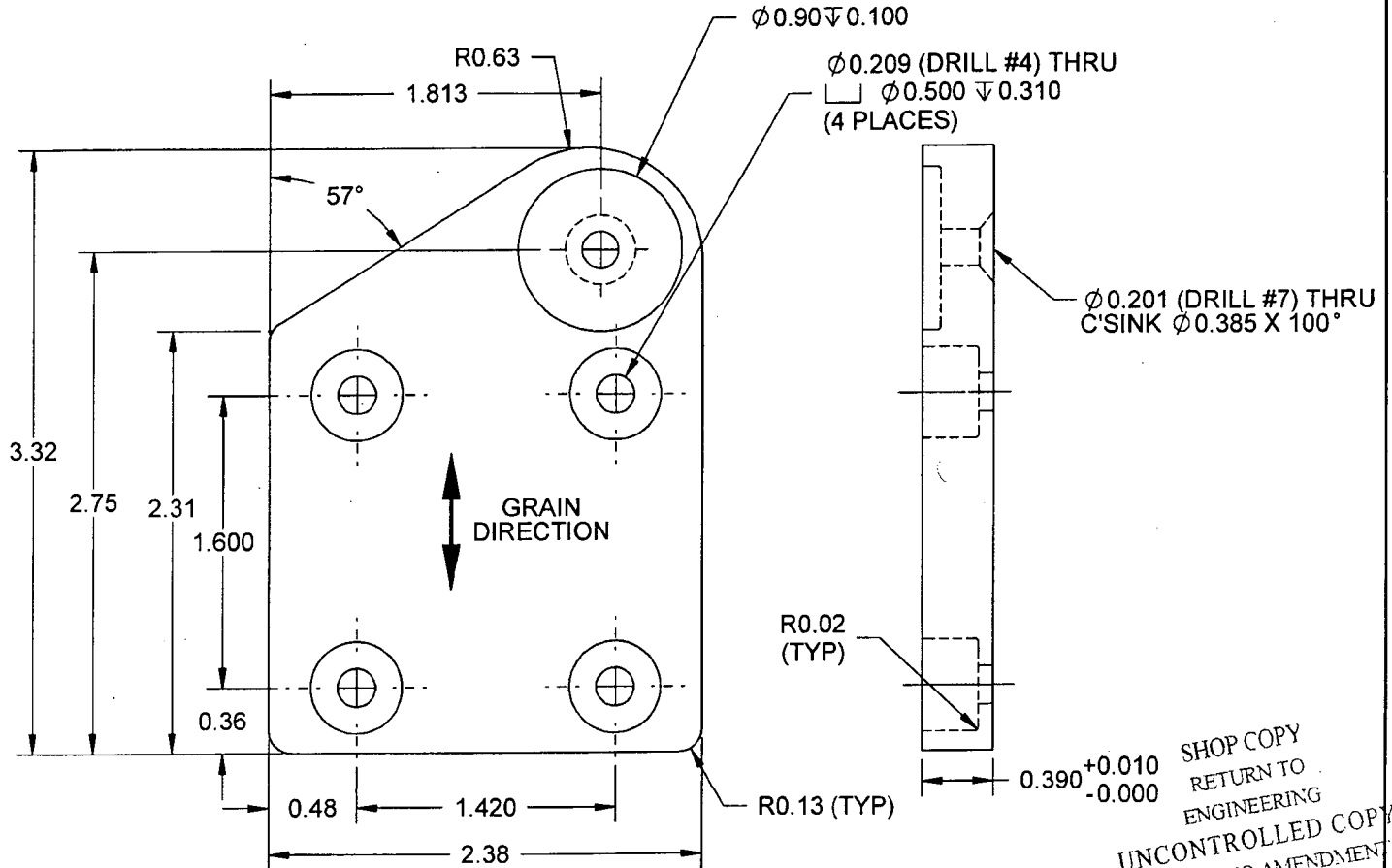
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RELEASED
07.04.02



D3573-7 ADAPTER (SHOWN)
D3573-8 ADAPTER (OPPOSITE)

1) MATERIAL: 6061-T6 (OR T651/T6510/T6511/T62) ALUMINUM BAR
PER QQ-A-225/8 OR QQ-A-200/8 OR AMS 4117/4128/4115/4116 OR AMS 4160
(REF DART SPEC M6061T6B)

2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "GREY SANDTEX" (4.3.5.6) PER DART QSI 005 4.3

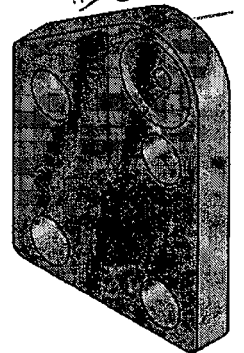
3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

4) IDENTIFY WITH DART P/N "D3573-7/-8" USING FINE POINT PERMANENT INK MARKER

5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX

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WORK ORDER 32830



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DART AEROSPACE LTD		Work Order:	32830
Description: <u>Adapter</u>		Part Number:	D3573-3
Inspection Dwg: D3573 Rev: <u>A</u>		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
3.31	$\pm .030$	3.314	—			
2.69	$\pm .030$	2.691	—			
2.31	$\pm .030$	2.310	—			
1.600	$\pm .030$	1.599	—			
.36	$\pm .030$.359	—			
1.19	$\pm .030$	1.186	—			
Ø.266	$\pm .005$.268	—			
Ø.209	$\pm .005$.210	—			
.500 ±.010						
.500	$\pm .010$.505	—			
.310	$\pm .010$.308	—			
.675	$\pm .010$.672	—			
.190	$\pm .010$.189	—			
.48	$\pm .030$.481	—			
1.420	$\pm .010$	1.418	—			
2.38	$\pm .030$	2.382	—			
.390	$\pm .010$.396	✓			
R. 63	$\pm .03$.63	✓			

Measured by: <u>[Signature]</u>	Audited by: <u>[Signature]</u>	Prototype Approval:
Date: <u>070808</u>	Date: <u>07.08.09</u>	Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	